

Date: Monday, 11/21/2005 1:15:27 PM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206/OH-58 SADDLE, OUTBOARD, LEFT SIDE
Job Number : 24853
Estimate Number : 10831
P.O. Number : N/A Part Number : D29321
This Issue : 11/21/2005 S.O. No. : N/A Drawing Number : D2932 REV B
Prsht Rev. : NC Project Number : N/A
First Issue : N/A Type : MACHINED PARTS Drawing Revision : B
Previous Run : N/A Material : N/A
Written By : SEE COMMENT BELOW Due Date : 11/28/2005 Qty: 4 Um: Each
Checked & Approved By : SEE ABOVE USER & DATE
Comment : Est: B 00.06.26 New DWG rev, (mpp 2069) EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6101003 7075-T7351 2X6.25X7.875



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

7075-T7351 2X6.25X7.875

Issue material from stock:

7075-T7351 Cut Size 2.0 x 6.25 X 6.0 Grain Along Long 6.0 Length

Batch No.: B 25247

SD/JL 06.04.07 (4)

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Program part number and batch number.

1-Inspect part number and batch number are programmed correctly.

2-Machine Step No 1 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet

3-Machine Step No 2 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet

4-Machine Step No 3 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet

5-Deburr

SD/JL 06.04.12 (4)

3.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet

SD/JL 06.04.12 (4)

4.0 QC1 INSPECT ALL DIM TO DIM SHEET







Comment: INSPECT ALL DIM TO DIM SHEET

SD/JL 06.04.12 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/04/12

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06-04-12	3	Key way machined .008-.015 too low off center. Origin was offset. Gr 2 saddles. Saddles stack up on index ridge on the skirt tubes.		Scrap and replace saddles.	J.L. 06-04-12	 06-04-12	 06-04-12	 06-04-12

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, OUTBOARD, LEFT SIDE

Job Number: 24853

Part Number: D29321

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

rnk 06/04/17

4

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

a.m 06-04-18

4

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

a.m 06-04-18

4

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

06/14/18 (4)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

AB 06/04/18 4

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/04/19

Job Completion



u 06/04/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	
Description: 206 Saddle, Outboard, Left side	Part Number:	D2932-1
Inspection Dwg: D2932 Rev. B		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. B and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.123	.123	.121	.122		
B	0.100	0.140		.123	.123	.121	.123		
C	0.100	0.140		.126	.127	.127	.127		
D	0.210	0.230		.224	.224	.222	.220		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.513	.513	.513	.513		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.497	2.496		
K	0.257	0.262	DT8683	✓	✓	✓	✓		
L	0.312	0.317	DT8686	✓	✓	✓	✓		
M	0.235	0.240		.240	.239	.239	.239		
N	0.100	0.140		.116	.116	.115	.118		
O	0.540	0.560		.546	.551	.550	.550		
P	0.490	0.510		.501	.495	.497	.497		
Q	3.715	3.725		3.724	3.720	3.720	3.720		
R	2.470	2.510		2.500	2.500	2.500	2.500		
S	0.240	0.270		.255	.251	.250	.250		
T	0.100	0.180		.145	.145	.145	.145		
U	1.625	1.635		1.630	1.631	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.368	1.367		
W	0.316	0.321	DT8690	✓	✓	✓	✓		
X	1.125	1.145		1.133	1.140	1.131	1.138		
Y	1.565	1.585		1.572	1.576	1.570	1.577		
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	J.L
Date:	06.04.11

Audited by:	En
Date:	06/04/12

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 17, 2005
03:30 pm

Work Order No : 0024853
Project Name : D2932-1
Project For : WK551
Work Order Type : Main
Main WO Number :
House Part Number : D2932-1
Description : 206 Saddle Left side
Manufactured : Yes
Amount Req'd : 4
Amount Done : 0
Start Date : 11-17-05
Est Finish Date : 12-21-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00

Order Entry No :
OE Value : 0.00

Est Margin : 0.000%
Actual Margin : 0.000%

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00